



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4885-3**Job Sheet 192636****Part No:** D4885-3**Job Qty:** 6 pcs**Part Name:** End Fitting**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/28/19**Job Tracking No:****Due Date:** 4/12/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP REV:A NEW ISSUE 14-01-28 JLM VERIFIED BY:JFS**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
105	Doosan - 1	6 pcs	4/12/19	4/12/19	0.00	6.00	Doosan - 1	
115	HAAS 5 Axis - B4B	6 pcs	4/12/19	4/12/19	0.00	4.50	HAAS - 5 - B4B	19-05-05
117	QC 2	6 pcs	4/12/19	4/12/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	19-05-05
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

**Container No:** S177164**Part:** D4885 - 3**Job No:** 192636**Serial No/Batch:** S177164**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/01/19

120 QC 8	6 pcs	4/12/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	19-05-06
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Outsource	6 pcs	4/12/19		SKY002-VC	2019-05-06 KH
140 Packaging 2-1 - Receive - B4B	6 pcs DP	4/12/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP MAY 08 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	

					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150	QC 6	6 pcs	4/12/19	0.00 0.00	QC 6 - 9	MAY 08 2019 DAS 40 9-89
					QC 6 - 68	
					QC 6 - 61	
160	Packaging 3-2 - Stock - B4B	6 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	5125 MAY 08 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	6 pcs	4/12/19	0.00 0.00	QC 21 - SA - 21	DAS 21 MAY 08 2019 9-88
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 105 - (Doosan Lathe)-Machine blank as per Machinist's turning detail, folio+drawing D4885-3.
 Descriptions: 115 - (HAAS CNC Vertical Machine)Mill as per folio FB547. Dwg. rev: A Folio rev: AA
 117 - QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8- Inspect parts - second check)
 130 - ISSUE P/O : _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 150 - (QC6- All purchased or subcontracted products)
 160 - (Identify as per dwg & Stock Location: _____)IDENTIFY AS PER QSI 044 6.1
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	2.4600 ft (.41 ea)	105-Doosan - 1	5/20/17
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
105-Doosan - 1	M17-4-H900-R2.000	2	18	0
Part Specifications				
Specifications could not be found.				

Plex 3/28/19 3:06 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	197636
Description: END Fitting		Part Number:	D4885-3
Inspection Dwg: D4885	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.45	$\pm .03$	1.453			Vern HPD	
.030	$\pm .01$	.032			↓	
Ø.500	$+ .006 / - .001$	.500			↓	
.017	$\pm .010$	.015			↓	
.43	$\pm .03$	.4325			H-gauge	
.500	$\pm .01$	.500			↓	
Ø.125	$+ .004 / - .001$	.126			Vern HPD	
30°	$\pm .5$	30°			↓	
Ø.670	$+ .000 / - .001$	.6692			Mic HPD	
1.41	$\pm .03$	1.410			Vern HPD	
.88	$\pm .03$	.880			↓	
R.250	$+/- .010$	.250	✓		Rad gauge	
1.06	$+/- .030$	1.064	✓		SK10 Vern	
.073	$+/- .010$	.072	✓		↓	
.11	$+/- .030$	.115	✓		↓	
Ø.749-.750	—	.7495	✓		SK02 Mic	
.68	$+/- .030$	.678	✓		↓	
3.58	$+/- .030$	3.585	✓		↓	
2.025	$+/- .005$	2.025	✓		Height gauge	
R.50	$+/- .030$	.500	✓		Rad gauge	
R.06	$+/- .030$	.062	✓		"	
R.13	$+/- .030$	.130	✓		"	
1.83	$+/- .030$	1.831	✓		↓	
.69	$+/- .030$	.690	✓		↓	
.36	$+/- .030$	.360	✓		↓	
.28	$+/- .030$	.280	✓		↓	
.063	$+/- .010$	.062	✓		↓	

Measured by: P/AS	Checked by: B.F	QC Inspector:
Date: 19-05-01	Date: 19-05-06	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____



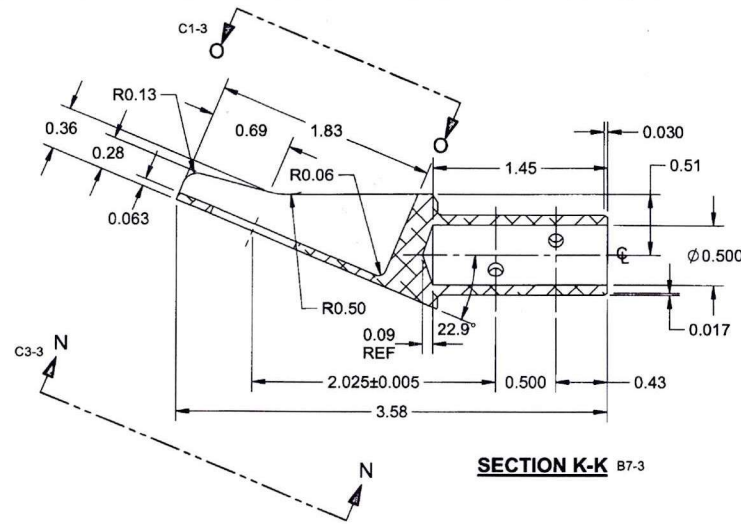
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

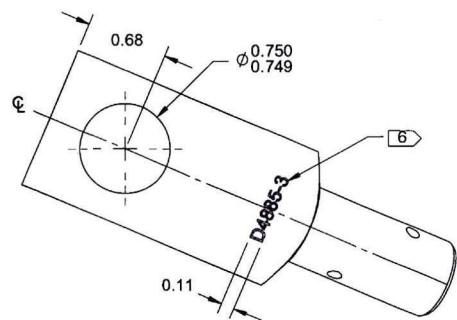
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

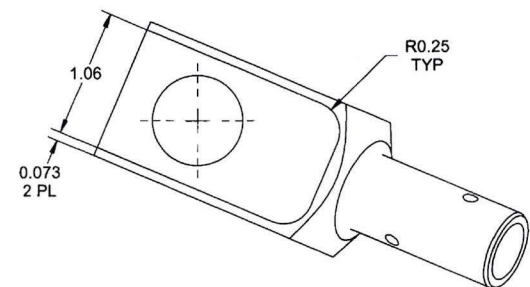
8 7 6 5 4 3 2 1



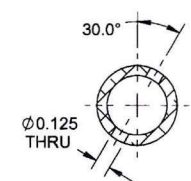
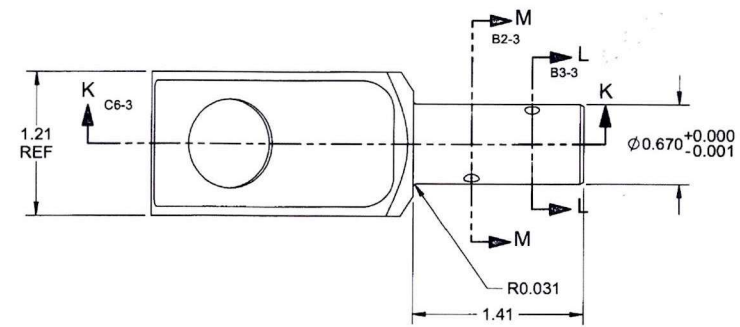
SECTION K-K B7-3



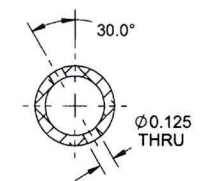
AUXILIARY VIEW N-N C8-3



AUXILIARY VIEW O-O D7-3



SECTION L-L B6-3



SECTION M-M B6-3

D4885-3 END FITTING

- NOTES:**
 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
 PER AMS 5643/ASTM A564
 DART SPEC M17-4-R
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
 ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
 7) WEIGHT: 0.22 lbs
 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4885	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	END FITTING	NTS
DATE	13.12.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043386



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043386

PO Date: 5/6/19

Due Date: 5/10/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192142	D4884-1	End Fitting, Eye : Various STC's (Outsource process - NDT per QSI038 4.1)ISSUE P/O	Firmed X6	-	5/10/19	6 pcs	0 pcs	6 pcs	\$14.833/pcs	\$89.00
2	192636	D4885-3	End Fitting : Various STC's ISSUE P/O : LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed X6	-	5/10/19	6 pcs	0 pcs	6 pcs	\$14.833/pcs	\$89.00

Grand Total: \$178.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit
www.dartaerospace.com for further explanation.

Plex 5/7/19 1:52 PM Dart.Guerin.Kimberley



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO40306	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043386
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

6 END FITTING EYE , P/N# D4884-1 , J/S# 192142

6 END FITTING , P/N# D4885-3 , J/S#192636

RECEIVED

MAY 08 2019

DART AEROSPACE LTD.

Action Taken:					Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT IAW ASTM E-1417M-16 ***NO CRACK FOUND*** PEN , ZL-37 MPO#: 23206 CLEANER SKC-S MPO15030, EMU.(ZR-10B, MPO23451), DEV. MPO15030, UV LIGHT M-20142					MAY 07 2019	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

DAS
40
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date: MAY 07 2019
Name: RICARDO YARGAS		